

# Work Order ID 52933

October 19, 2009 11:02:01 AM

Page 1

Item ID: D3991-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Packer

Start Date: 10/19/09 Start Qty: 8.00

Cust Item ID:

Required Date: 10/19/09 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-15* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3991	A								

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3991

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*= 7 m-l 09/11/02*

*(25x)*

*(25)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*B 9-10-30*

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Item ID: D3991-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Packer

Start Date: 10/19/09 Start Qty: 8.00



Cust Item ID:

Required Date: 10/19/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	8/11/02			(25)	/		
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	MO 09/11/03			125			
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	11/09/11/03			(125)	/		

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Accept

Setup Start

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Stop

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Start Date: 10/19/09 Start Qty: 8.00

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Identify as per dwg & Stock Location: 139

0.00



Packaging Memo

0.00

Packaging

09/11/05 25

160 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

09/11/04

MF

09-11-04

# Picklist Print

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Page 1

Work Order ID: 52933

Parent Item: D3991-1RevA-PRELIM

Parent Item Name: Packer

Start Date: 10/19/09

Required Date: 10/19/09

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	156.9479	0.2046	7		



6061-T6 Sheet 0.032"



189-10-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

156.9479

110063

0.859

112763

96

16954

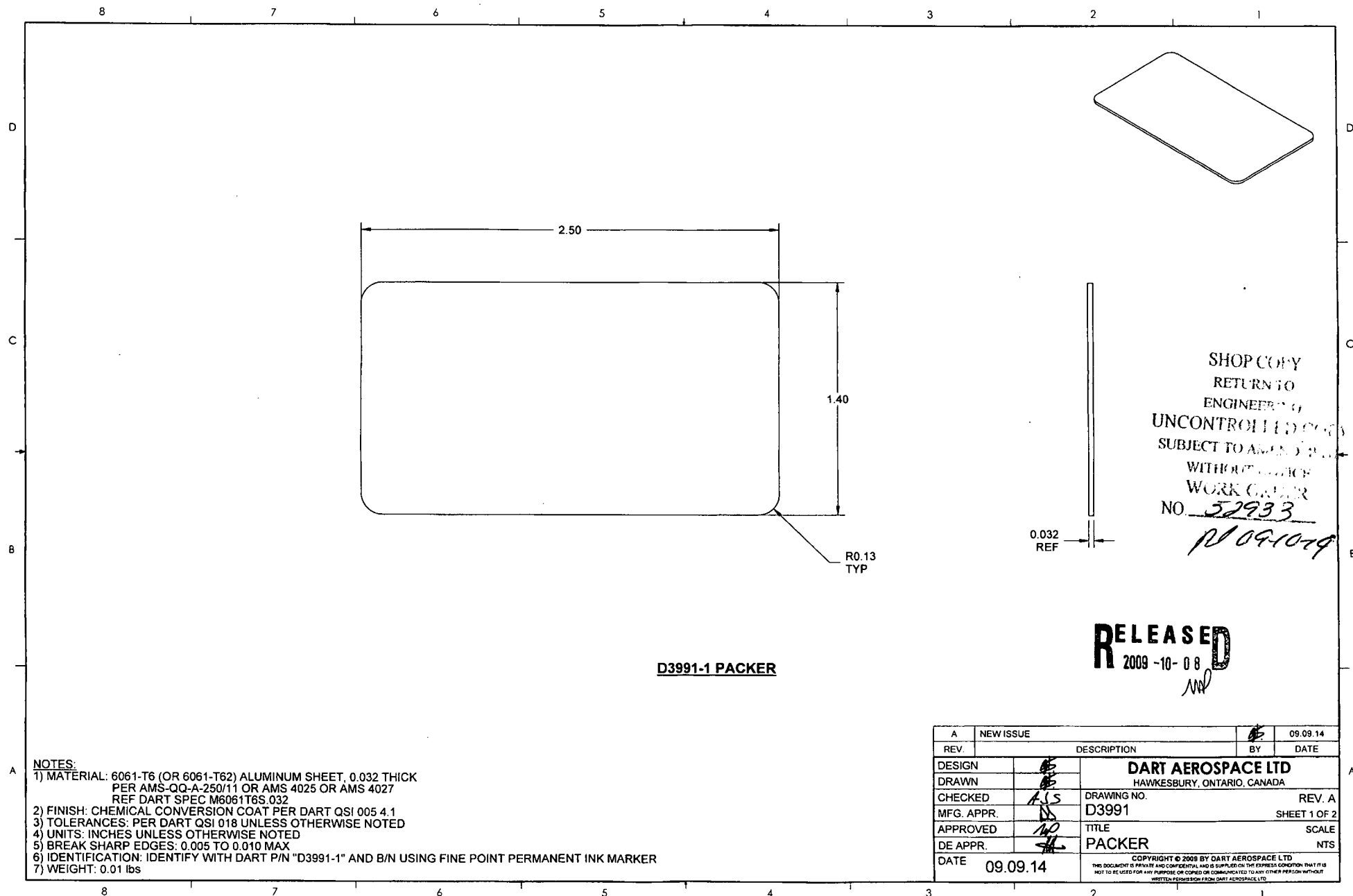
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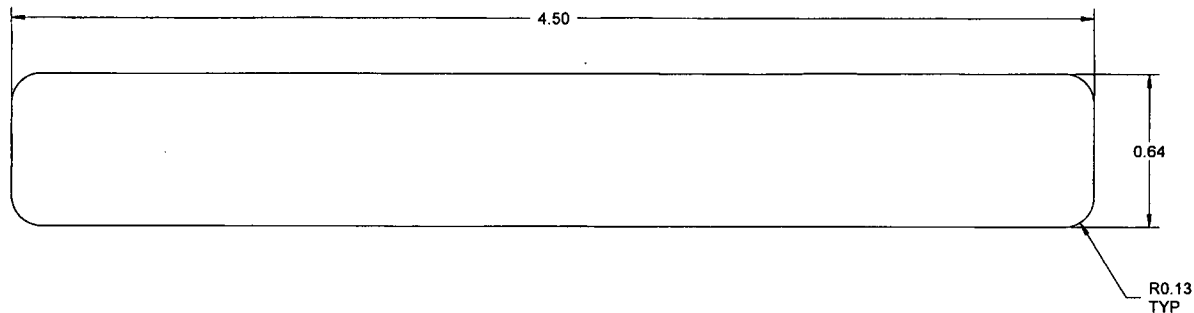
18375

51.0989

110063







# **D3991-3 PACKER**

SHAWMUT  
RESEARCH  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENTS  
WITHOUT NOTICE  
WORK ORDER NO. 52933

**RELEASED**  
2009-10-08  
ND

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3991	SHEET 2 OF 2
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	PACKER	NTS
DATE	09.09.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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